

Date: Tuesday, 7/1/2008 2:33:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING
Job Number	: 40181		
Estimate Number	: 10091		
P.O. Number	:	Part Number	: D31835
This Issue	: 7/1/2008 S.O. No. :	Drawing Number	: D3183 REV. C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : PURCHASED PARTS	Drawing Revision	: C1
Previous Run	: 39759	Material	:
Written By	:	Due Date	: 7/8/2008 Qty: 60 Um: Each
Checked & Approved By	: <u>08.07.01</u>		
Comment	: Est: A-03.03.27 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 66669

Bearing as per Dwg D3183

Single row, deep groove, Conrad type, shielded

Possible Supplier: NSK P/N 6800ZZ

Certificate of conformity note is required

08/07/02(60)

2.0	6800ZZ	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)
 BEARING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

08/07/07(60)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

08/07/07 (+60) counted

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 758/7/7762x56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:33:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 40181

Part Number: D31835

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

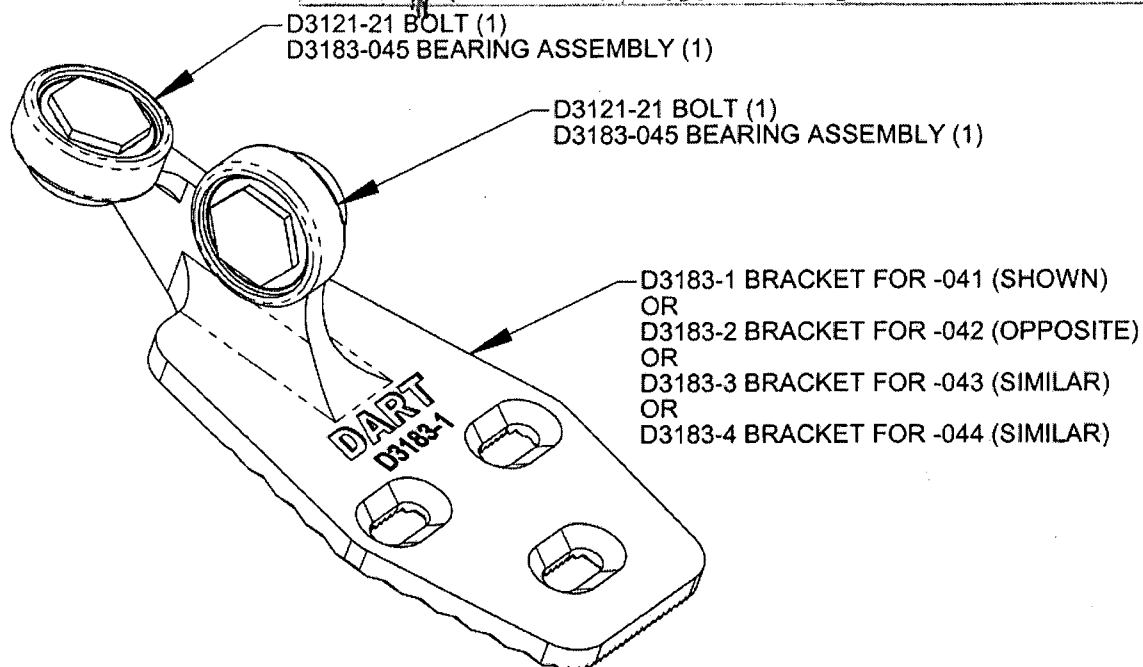
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

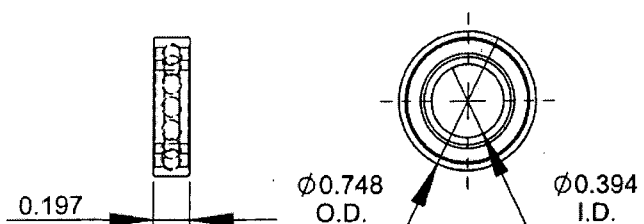
DART

COPY ISSUED

DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SCALE 1:1	
A.	03.01.24	NEW ISSUE	
B.	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C.	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01

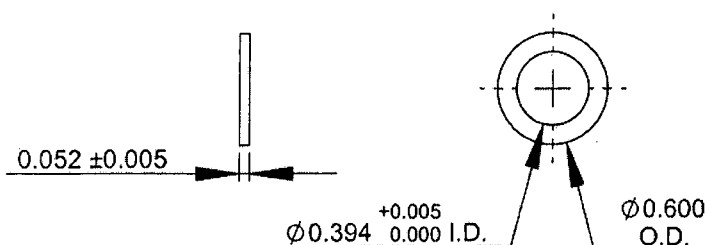
D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40181



D3183-7 WASHER

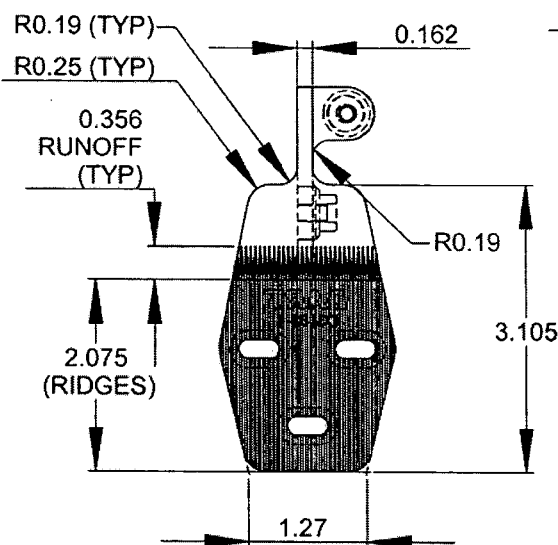
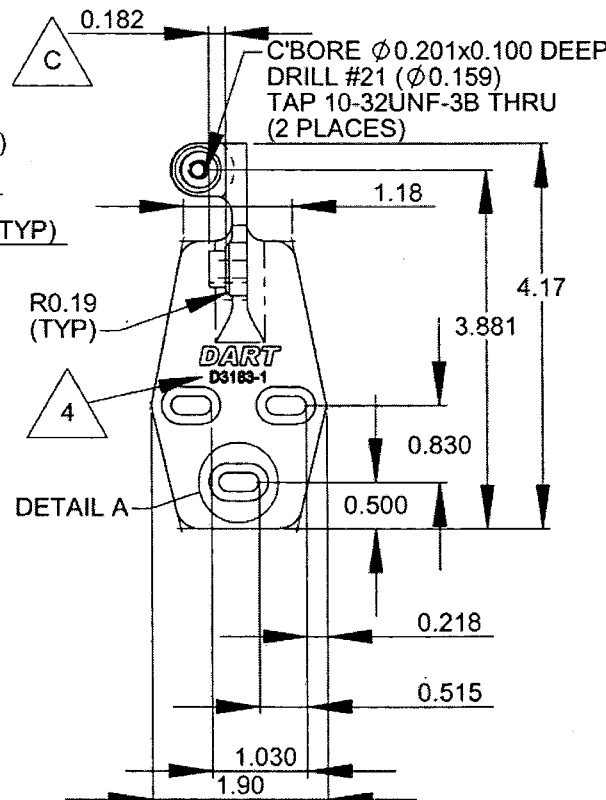
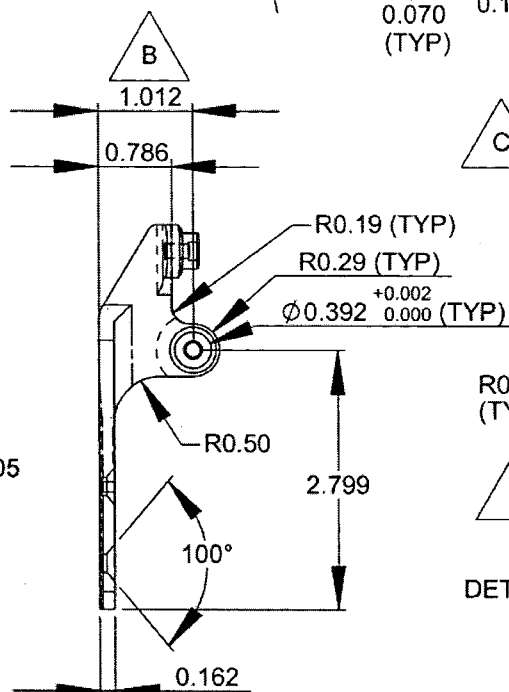
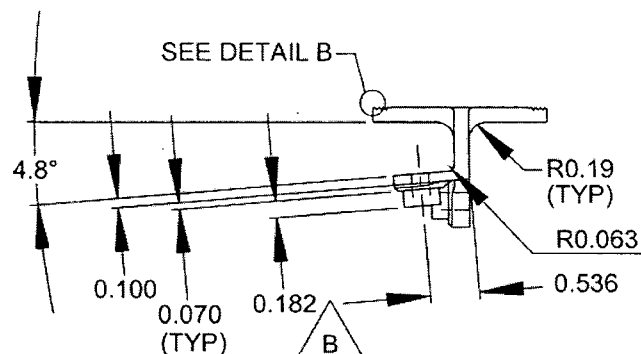
- 1) MATERIAL: AISI 303 ROUND BAR (M303R)
ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. C SHEET 2 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SCALE 1:2	

RELEASED
04.03.01

D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. 70181

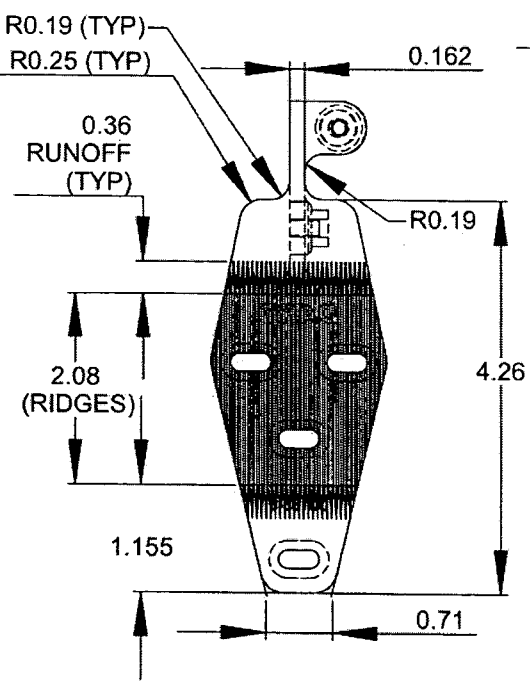
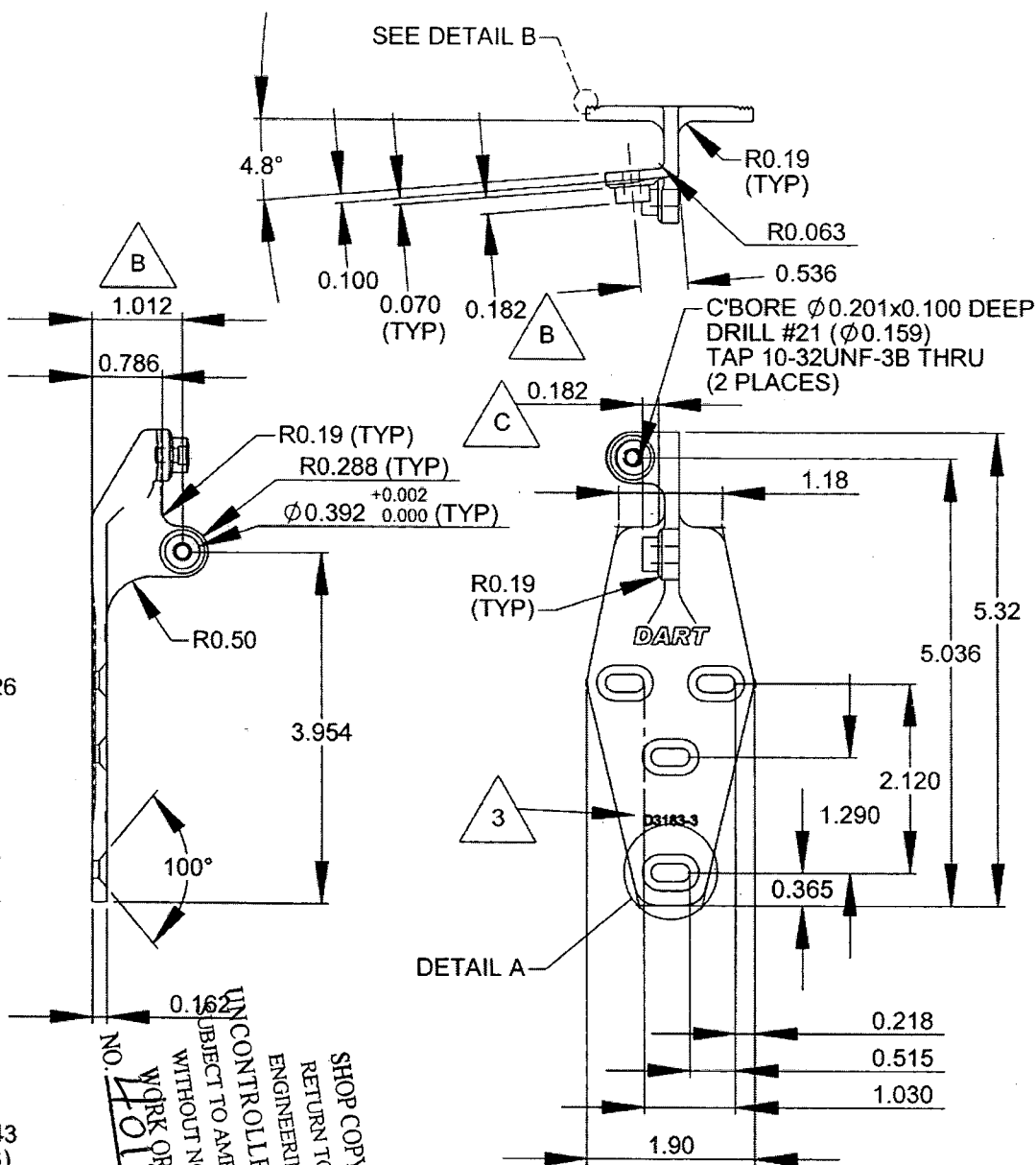
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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 3 OF 4
TITLE	BRACKET ASSEMBLY	SCALE
		1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 10181

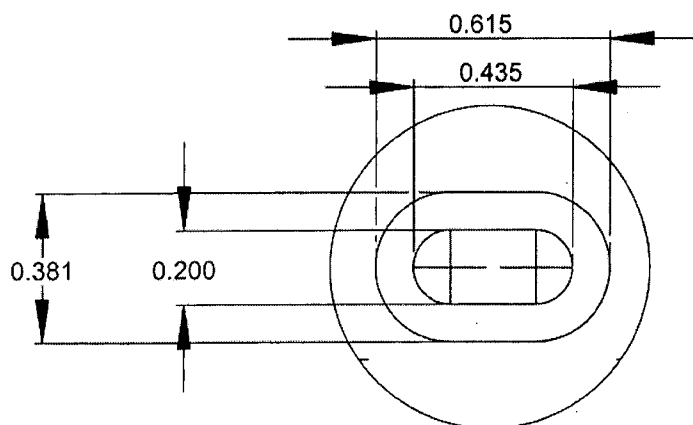
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04-08-01

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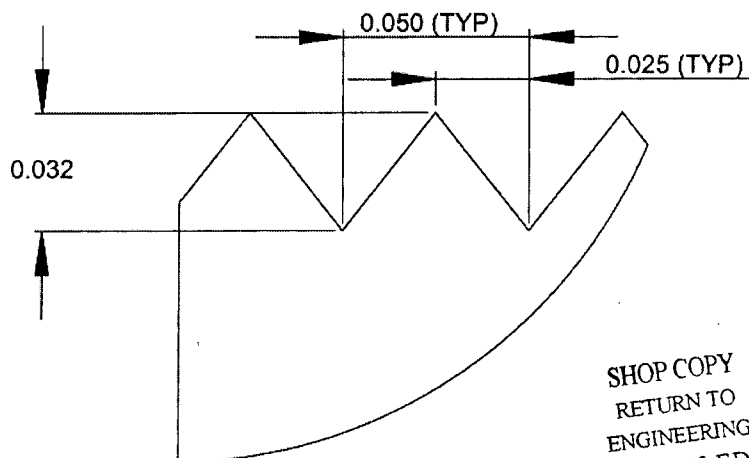


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



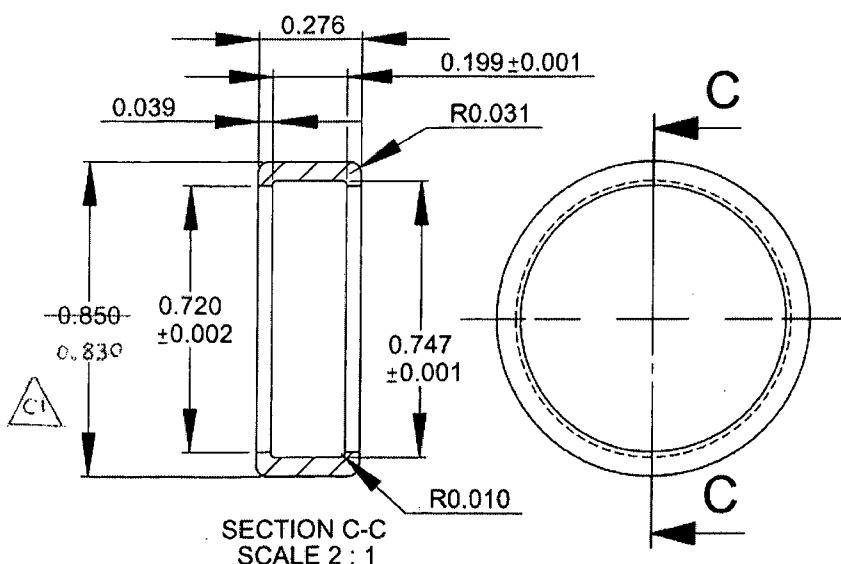
DETAIL A (2 : 1)

RELEASED
04.03.01



DETAIL B (20 : 1)

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40181



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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GENERAL BEARING SERVICE

www.gbs.ca

385 MAIN ST E, WARESBURY, ONTARIO M6A 1A8 (613) 632-9914

ORDER DATE: JUL 7, 2008

GST # R12345678

SOLD TO: DART PROSPERITY LTD.
1150 BARRINGTON STREET
WARESBURY, ON

R09-447

SALE MADE BY: ON
SHIP VIA:

CUSTOMER ORDER #: 00000009

PST LICENSE: 61225887

PRODUCT	DESCRIPTION	SOLD	SHIP	PRICE	EXTENSION
6000-72	BALL BEARING	16	16	4.89	78.24
				B.S.T.	3.91

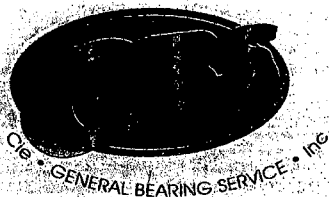
6000-72

PHONE SLIP NO: 630354-0

RECEIVED BY:

1338308

THIS FORM MUST BE COMPLETED AND SUBMITTED TO THE IRS
DO NOT WRITE IN PENCIL OR IN INK ON THE REVERSE SIDE



cie
GENERAL BEARING SERVICE
Inc.
www.gbs.ca

386 MAIN ST E, HAWKESBURY, ONTARIO K6A 1A8 (613) 632-9914

GST # R101979094

ORDER DATE: JUL 7, 2000

SOLD TO: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY, ON.

K6A-1K7

SALE MADE BY: DR
SHIP VIA:

CUSTOMER ORDER #: 00006669

PST LICENCE: 6122-5207

PRODUCT	DESCRIPTION	GOLDT	SHIP	PRICE	EXTENSION
6800-22	BALL BEARING	44	44	4.89	213.16
				G.S.T.	10.76

08/07/00

PACKING SLIP NO: 630855-0

RECEIVED BY: *[Signature]*

1220210

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DOIT ETRE IMPRIME PAR ORDINATEUR POUR ETRE VALIDE E & O.E.

DART

Purchase Order

Date Jul 02, 2008	Page 1
Purchase Order Number PO00006669	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED
663276

Vendor Address:

General Bearing Service
386 Main Street
Hawkesbury, ON K6A 1A5
Phone (613) 632-9914
Fax (613) 632-2751

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-GEN001	Jul 02, 2008	N30		Jul 04, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
60.0000	6800ZZ	Bearing Comments: AS PER DWG D3183 REV. C1 SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED NSK P/N: 6800ZZ B40181	7/4/2008	No	4.890000	Each	293.40

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Comments:**Tax Summary:**

GST 14.67
GSTME 0.00
GSTND 0.00

Less:

included tax

0.00

Subtotal

293.40

Total tax

14.67

Total purchase order in

CAD Dollars

308.07

Entered By: CL CLAVOIE

Approved By: U